

5107

<b>DART AEROSPACE LTD.</b>	<b>Work Order :</b>	<b>22221</b>
<b>Description: 206 Saddle, Outboard, Left Side</b>	<b>Part Number:</b>	<b>D2665-1</b>
<b>Drawing: D2665 Rev B</b>	<b>Qty:</b>	<b>8</b>

Step	Location	Procedure	By	Date	Qty
1	EXPEDITING	Issue Work Order <i>Dwg. not required RF 02/09/16</i>	<i>EP</i>	<i>05.01.13</i>	<i>8</i>
2	STORES	Issue material from stock: 7075-T7351 Cut Size 2.0 x 6.25 X 7.88 Grain Along Long 7.88 Length (D6101-003) RF 02/09/16 Batch No: <i>B20988B</i>	<i>EP</i>	<i>05/02/16</i>	<i>8</i>
3	HAAS	Program batch number.	<i>EP</i>	<i>05/02/16</i>	<i>8</i>
4	QC	Inspect part number and batch number are programmed correctly.	<i>EP</i>	<i>05/02/16</i>	<i>8</i>
5	HAAS	Fixturing W/O No. <i>N/A</i> Fixturing Inspection last completed on <i>05/02/16</i> by <i>EP</i>	<i>EP</i>	<i>05/02/16</i>	<i>8</i>
8	HAAS	Machine Step No 1 of Folio and visually inspect as per attached Dimension Sheet	<i>EP</i>	<i>05/02/16</i>	<i>8</i>
9	HAAS	Machine Step No 2 of Folio and visually inspect as per attached Dimension Sheet	<i>EP</i>	<i>05/02/16</i>	<i>8</i>
10	HAAS	Machine Step No 3 of Folio and visually inspect as per attached Dimension Sheet	<i>EP</i>	<i>05/02/16</i>	<i>8</i>
11	LAGUN	Machine Keyway and inspect per attached dimension sheet	<i>EP</i>	<i>05/02/16</i>	<i>8</i>
12	METAL	Deburr	<i>EP</i>	<i>05/02/16</i>	<i>8</i>
13	HAAS	Inspect Level 1	<i>EP</i>	<i>05/02/16</i>	<i>8</i>
14	QC	Inspect Level 8	<i>EP</i>	<i>05/02/16</i>	<i>8</i>
15	METAL	Acid etch and Alodine as per QSI 005 4.1	<i>MM</i>	<i>05.02.14</i>	<i>8</i>
16	FINISHING	Powder Coat High Gloss White (4.3.5.1) per Dart QSI 005 4.3	<i>MM</i>	<i>05.02.22</i>	<i>8</i>
17	QC	Inspect Level 3	<i>CL</i>	<i>05/02/23</i>	<i>8</i>
18	STORES	Pack in foam, identify and stock.	<i>CL</i>	<i>05/02/23</i>	<i>8</i>
19	EXPEDITING	Close Work Order Job Cost / Part <i>88.19 595 05/02/24</i> (8)	<i>EP</i>	<i>05.03.02</i>	<i>8</i>

Rev	Date	Change	Revised By	Approved
A	97.07.24			
B	98.09.02	Inspection Levels, Added Powder Coat	KS	
C	00.11.01	Removed P/O for Powder Coat – in house process	EC	

RELEASED

DEC 18 2000

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector	

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	<b>22221</b>
<b>Description:</b> 206 Saddle, Outboard, Left side	<b>Part Number:</b>	<b>D2665-1</b>
<b>Inspection Dwg:</b> D2665 Rev. B		<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2665 Rev. B and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		0.131	0.132	0.132	0.134		
B	0.100	0.140		0.134	0.135	0.131	0.132		
C	0.100	0.140		0.125	0.128	0.127	0.127		
D	0.210	0.230		0.219	0.219	0.221	0.219		
E	1.245	1.255		1.248	1.249	1.251	1.249		
F	1.245	1.255		1.248	1.248	1.251	1.249		
G	5.990	6.010		6.000	5.999	5.999	6.002		
H	0.510	0.515		0.510	0.510	0.510	0.510		
I	1.674	1.684		1.678	1.678	1.678	1.678		
J	2.495	2.505		2.499	2.500	2.499	2.499		
K	0.257	0.262	DT8683						
L	0.312	0.317	DT8686						
M	0.235	0.240		0.235	0.235	0.235	0.235		
N	0.100	0.140		0.119	0.120	0.118	0.119		
O	0.540	0.560		0.549	0.546	0.546	0.546		
P	0.490	0.510		0.500	0.502	0.498	0.502		
Q	3.609	3.619		3.614	3.614	3.614	3.611		
R	2.470	2.510		2.499	2.499	2.501	2.499		
S	0.240	0.270		0.254	0.257	0.253	0.254		
T	0.100	0.180		0.140	0.135	0.135	0.135		
U	0.313	0.318	DT8686						
V	1.125	1.145		1.133	1.133	1.133	1.133		
W	1.565	1.585		1.570	1.570	1.571	1.572		
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: <b>EP</b>	Audited by: <b>JML</b>
Date: <b>05/02/14</b>	Date: <b>05/02/14</b>

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	<b>#</b>

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	<b>22221</b>
<b>Description:</b> 206 Saddle, Outboard, Left side	<b>Part Number:</b>	<b>D2665-1</b>
<b>Inspection Dwg:</b> D2665 Rev. B		<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2665 Rev. B and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		0.133	0.133	0.133	0.136		
B	0.100	0.140		0.131	0.131	0.131	0.132		
C	0.100	0.140		0.129	0.127	0.128	0.124		
D	0.210	0.230		0.225	0.227	0.218	0.215		
E	1.245	1.255		1.251	1.245	1.245	1.245		
F	1.245	1.255		1.251	1.249	1.245	1.245		
G	5.990	6.010		6.001	5.998	6.002	6.002		
H	0.510	0.515		0.510	0.510	0.510	0.510		
I	1.674	1.684		1.678	1.678	1.675	1.675		
J	2.495	2.505		2.499	2.499	2.501	2.500		
K	0.257	0.262	DT8683						
L	0.312	0.317	DT8686						
M	0.235	0.240		0.235	0.235	0.235	0.235		
N	0.100	0.140		0.119	0.119	0.117	0.117		
O	0.540	0.560		0.545	0.545	0.545	0.543		
P	0.490	0.510		0.499	0.495	0.498	0.499		
Q	3.609	3.619		3.612	3.612	3.612	3.612		
R	2.470	2.510		2.499	2.495	2.499	2.499		
S	0.240	0.270		0.254	0.254	0.254	0.254		
T	0.100	0.180		0.135	0.135	0.135	0.135		
U	0.313	0.318	DT8686						
V	1.125	1.145		1.134	1.133	1.134	1.135		
W	1.565	1.585		1.569	1.569	1.569	1.571		
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	EP
Date:	05/02/11

Audited by:	TRC
Date:	05/02/14

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	#

# Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

Jan 13, 2005  
10:56 am

Work Order No : 0022221  
Project Name : D2665-1  
Project For : WK507  
Work Order Type : Main  
Main WO Number :  
House Part Number : D2665-1  
Description : Saddle, LH Fwd Aft Out  
Manufactured : Yes  
Amount Req'd : 8  
Amount Done : 0  
Start Date : 01-13-05  
Est Finish Date : 02-15-05  
Act Finish Date :  
Drawings Req'd : No  
Ok for Approval :  
Approval Rec'd :

Department Code:  
Burden Flags : NNNNNNN  
WO Status : Open  
Invoice State : Not Invoiced  
Invoice Date :  
Invoice Number :  
Invoice Amount : 0.00  
Order Entry No :  
OE Value : 0.00  
Est Margin : 0.000%  
Actual Margin : 0.000%  
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00